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Setup Start

[illegible]

Stop

[illegible]**Cust Item ID:**

Abstract

Customer:

Reference:

Run Start

RESEARCH DESIGN

Date:

Date:

Stop



**Insp.
Stamp**

Revision Nbr

D6103

Rev B

0.00

[illegible]

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10903 ☐ a) Description: Alluminum round billet ☐ b)
Ø3.500" x 12.500" long ☐ c) Tolerance on all dimensions are +0.030"/-0.000"
☐
d) Material: 7075-T7351 (QQ-A-225/9) ☐ Material certification required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

00000000000000000000000000000000

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

120

QC6- Inspect dimensions to drawing

0.00

00000000000000000000

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54271

December 7, 2009 12:54:54 PM

Page 2

Item ID: D6103-003

Accept

Setup Start

Revision ID:

Stop

Item Name: Round Billet, Aluminum

Start Date: 12/07/09 Start Qty: 40.00

Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>MAT</u> Memo	0.00 0.00	<u>MR 09/12/29</u>			<u>44</u>			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>10.01.05</u>			<u>MR 09-12-29</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

December 7, 2009 12:54:53 PM

Work Order ID: 54271



Parent Item: D6103-003



Parent Item Name: Round Billet, Aluminum



Start Date: 12/07/09

Required Date: 12/18/09

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6103-003P  round alum billet		Purchased	No			110	Each	0.0000	40.0000 	<i>Pc 9/12/12</i> <i>12/4</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

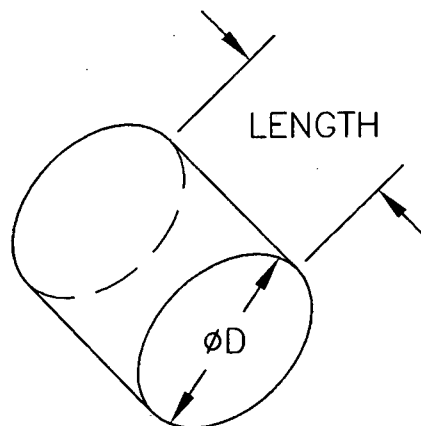
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07



C207112107
W10.54271

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Pack Slip No:9901305

Ship From: Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 17-DEC-09	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN	BOL No 159583-2	Delivery No 9901305	

Shipment Details	Final Destination Branch - MON
-------------------------	---------------------------------------

Order No 448776	Line No 1	Item No 8808.MO	Description 3.5000.RD.7075.T7351.ALUMINUM.CF.132.0000-144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS 4124, AMS-QQ-A-225/9, ASTM B211			
Purchase Order No 10903		Part Number		Ordered Qty 44 PCS	Invoice Qty 44 PCS	Backorder Qty
Details						
Mill	Heat Number 20123374	Mech Id	PCS 44	Width (IN)	Length (IN)	Shipped Qty (LBS) 533.52

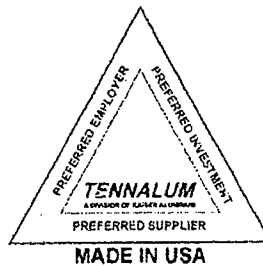
These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.	
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.	
This material has been received and inspected by:	Date:

cmk 09/12/29

KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://Certs.KaiserAluminum.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES. Material complies with FAR BAA (FAR 52.225-1, Buy American Act-Supplies), DFARS BAA (DFARS 252.225-7001 Buy American Act & Bal of Payments Prog), and FAR TAA (FAR 52.225-5 Trade Agreements) AS9100B:2004 Material is RoHS compliant.

Castle Metals FP

HEAT NUMBER 20123374
MECHANICAL ID _____
ITEM CODE 8808
LOT NUMBER _____
PO NUMBER 17132
RECEIPT DATE 9-15-09
SUPPLIER Kaiser
SPECIFICATION _____
LCS N
COMMENT _____
APPROVED BJ

CM 09/12/29

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

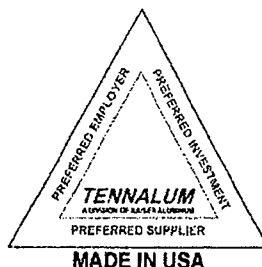
Plant Serial: 125177

Kaiser Order Number: 653278

KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT

<http://Certs.KaiserAluminum.com>

CUSTOMER PO NUMBER: 01-23172-1 17132		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 653278	LINE ITEM: 1	SHIP DATE: 09/08/2009	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 1965 lbs.	QUANTITY: 14 pcs.	B/L NUMBER: 29771	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA			SOLD TO: A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA		

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20123374	71.9	60.0	16.0	39.2

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.08	0.24	1.6	0.02	2.7	0.19	6.0	0.02			20123374
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min			1.2		2.1	0.18	5.1				

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-9

amf
09/12/29

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

Plant Serial: 125177

Kaiser Order Number: 653278



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO10903**

Purchase Order Date 12/07/09

PO Print Date 12/07/09

Page Number 1 of 1

Order From :

VC-MET001

METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - BOX B9204 PO BOX 9100
TORONTO, ON M4Y 3A5
CA

FAKED
06/12/10

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 694 9575	Requisition Nbr	
Vendor Fax	514 695 3281	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6103-003P	round alum billet	12/18/09 Yes	40.00 Each	Yours ppd	\$65.0000	\$2,600.00

ack 49 Dec 12/10

Special Inst: AS PER DWG D6103 REV.B
B54271
SIZE: 3.50" X 12.500" LONG
TOLERANCE ON ALL DIMENSION ARE
+0.030"/-0.000"
MATERIAL: 7075-T7351 (QQ-A-225/9)

PO Total: \$2,600.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

09/12/29

Change Nbr: 1

Change Date: 12/07/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable